



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

647.7820

Job Sheet 172472



Part No: 647.7820

Job Qty: 1 ea

Part Name: Cross Bracket Aft



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/16/18

Job Tracking No:

Due Date: 3/3/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV A IPP Rev A New Issue JFS 15/04/29 Verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/2/18	3/2/18	0.00	0.00	Start Up Machining-1		
100	Bandsaw	1 pcs	3/2/18	3/2/18	0.00	0.00	Bandsaw1		
110	CNC Vertical Machining	1 pcs	3/3/18	3/3/18	0.00	7.89	HAAS 5 Axis		
120	QC	1 pcs	3/3/18	3/3/18	0.00	0.00	QC1		
130	QC	1 pcs	3/3/18	3/3/18	0.00	0.00	QC8 Machining-1		
140	Outsource	1 pcs	3/3/18	3/3/18	0.00	0.00	Outsource4		
150	Packaging	1 pcs	3/3/18	3/3/18	0.00	0.00	Packaging2		
155	QC	1 pcs	3/3/18	3/3/18	0.00	0.00	QC5		
180	Packaging	1 pcs	3/3/18	3/3/18	0.00	0.00	Packaging3-1		
190	QC21-SA	1 Ea	3/3/18	3/3/18	0.00	0.00	QC21		

Part Op 100 - Cut Blank at 14.900"

Descriptions: 110 - 1-Machine per folio FB376 DWG REV: _____ FOLIO REV: _____ 2- Deburr and break all sharp edges

120 - QC1- Inspection performed by CMM Inspect on CMM as per folio CMMA003. DWG REV: _____ CMM PROG.

REV: _____

130 - QC8- Inspect parts - second check

140 - Outsource process-Anodize per QSI017 4.1.10.1 Issue P/O TO ATG: 039182 Anodize & prime as per Dwg. 647.7800

150 - Receive & Inspect for Damage & Mat'l Certs

155 - QC5- Inspect part completeness to step on W/O

180 - Identify as per dwg & Stock Location: _____ ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - QC21- Final Inspection - Work Order Release

S045122

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.750X2.250	7075-T6 Sheet 1.750" X 2.250"	1.2420 ft (1.242 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S1.750X2.250	1	32	0

Part Specifications

Specifications could not be found.



Container No: 8045923

Part: 647.7820

Job No: 172472

Serial No/Batch: 8045923

Revision: 647.7800

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkebury, ON K84 1K7
CANADA
TEL: 1 813 832-8200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 02/27/18

DART AEROSPACE LTD		Work Order: 172 472
Description: Bracket		Part Number: 647-7820
Inspection Dwg: 647.7800 Rev: A		Page 1 of 1

INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC						
Ø.089	+/- .004/- .001	.093	✓		SLIO	vern
1.520	+/- .005	1.521	✓		"	
40.4°	+/- .5°	40.4°	✓		Protractor	
30.8°	+/- .5°	30.8°	✓		↓	
9.4°	+/- .5°	9.4°	✓		↓	
4.8°	+/- .5°	4.8°	✓		↓	
R.250	+/- .005	.250	✓		Rad gauge	
.378	+/- .002	.378	✓		SLIO	vern
.650	+/- .005	.653	✓		↓	
.450	+/- .005	.450	✓		↓	
.561	+/- .005	.561	✓		↓	
.858	+/- .005	.858	✓		↓	
5.779	+/- .005	5.779	✓		↓	
9.724	+/- .005	9.724	✓		↓	
R70.02	+/- .010	70.02	✓		Rad gauge	
Manual Milling						
R9.509	+/- .005	9.509	✓		"	
13.077	+/- .005	13.077	✓		Height gauge	
14.520	+/- .005	14.520	✓		"	
.273	+/- .005	.273	✓		"	
.390	+/- .005	.391	✓		Deep Throat Mic	
.450	+/- .005	.450	✓		SLIO	vern
.560	+/- .005	.560	✓		"	
.760	+/- .005	.760	✓		"	
1.200	+/- .005	1.1925			"	
.645	+/- .005	.645	✓		"	
51.6°	+/- .005	51.6°	✓		Protractor	
R.200	+/- .005	.200°	✓		Rad gauge	
Ø.177	+ .005/- .001	.178	✓		SLIO	vern
100X45°	+/- .005	100X45°	✓			
Measured by: 20		Audited by: Ha		Preliminary Approval:		
Date: 18-02-26		Date: 18-02-27		Date:		

Rev	Date	Change	Revised by	Approved
A	14.07.14	New Issue	KJ	

647.7800 Deviation

1

ML Michael Lee Reply all |
Yesterday, 1:17 PM
Pablo Bravo; Chr

Thank you Pablo !

Yes, the 0.645 holes are within tolerance.

@Chris; can you please provide Simon/Guillaume with the deviation.

Thank you,

Mike

Pablo Bravo |
Yesterday, 12:41 PM

Mike,

The deviation is acceptable. Can you please confirm that hole to hole distance (.645 +- .002) is still being held? That's more critical for the mating part.

Thanks,

Pablo

ML Michael Lee |
Yesterday, 9:58 AM

SKMBT_C454_180226...

42 KB

Download Save to OneDrive - Eagle Copters Ltd

Good Morning Pablo,

The shop has requested a deviation to part 647.7800. (attached)

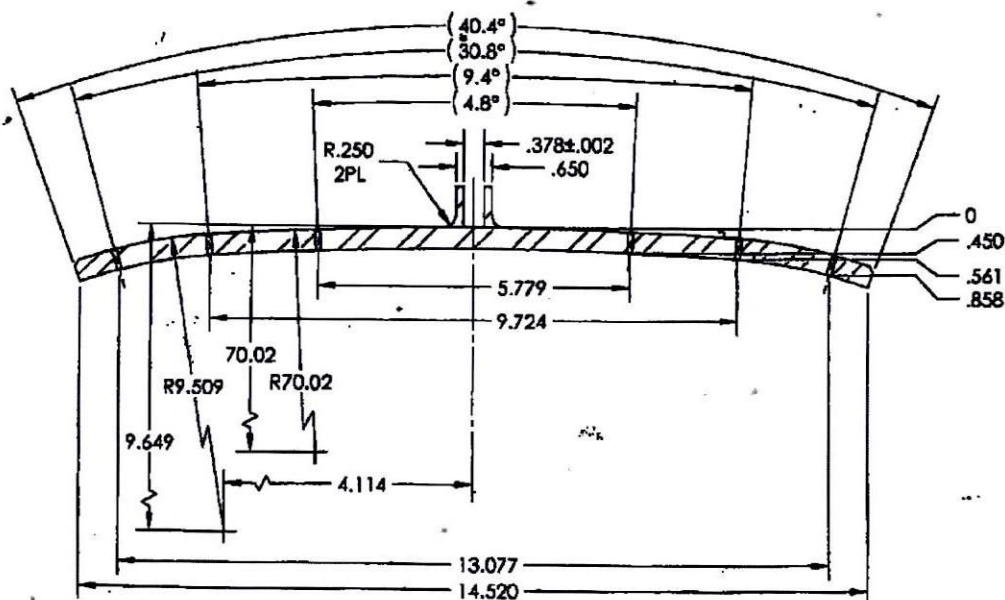
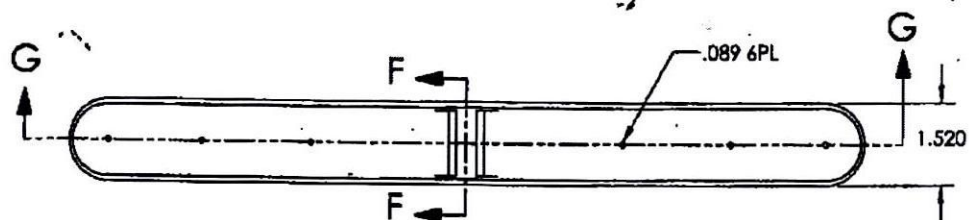
Please provide as soon as you have time.

Thank you,

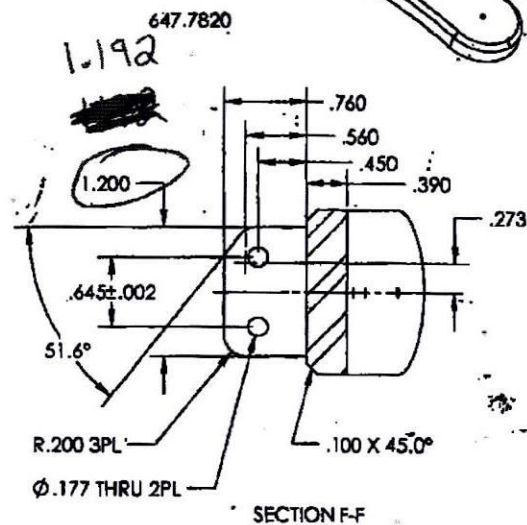
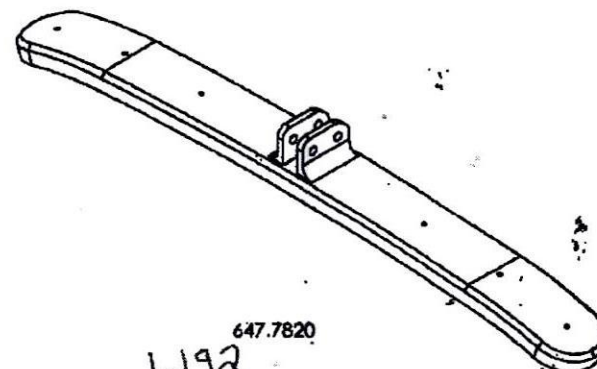
Mike

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES IS PROHIBITED.

REV.	DESCRIPTION	DATE	APPROVED
1			
2			
3			



SECTION G-G



SECTION F-F

DESIGNED BY	DATE	APICAL INDUSTRIES
DRAWN BY	DATE	2402 TEMPLE HEIGHTS DR.
CHECKED BY	DATE	OCEANSIDE, CA 92056-3512 (760) 724-6300
APPROVED BY	DATE	
DATE	DATE	
SCALE	SCALE	
SHEET	SHEET	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO039182

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO039182

PO Date: 3/2/18

Due Date: 3/16/18

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Lavoie, Chantal
clavoie@dartaero.com

E-MAILED
MAR 17 2018

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

				Items						
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	170833	D5501-3	Body, Lower Cutter, Short Issue P/O to ATG: _____ HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 PRIME AS PER IAW MIL- P-23377J TYPE 1 CLASS N ***1-2 MIL MAX AS PER QSI005*** As Per Dwg D5501 Rev. A7 Certification of Conformity is required	Firmed	3/26/18	6 pcs	0 pcs	6 pcs	\$16.33/pcs	\$97.98
2	170453	646.3210	Support Issue P/O to ATG: _____ 1- Hard Anodize Color Black and Prime as per Dwg 646.3200	Firmed	3/26/18	12 pcs	0 pcs	12 pcs	\$15.18/pcs	\$182.16
3	171981	646.3312	Center Plate Issue P/O to ATG: _____ Hard Anodize Color Black, Prime as per Dwg 646.3300 Rev. N/C	Firmed	3/26/18	20 pcs	0 pcs	20 pcs	\$12.88/pcs	\$257.60
4	170464	646.3610	Filler Issue P/O to ATG: _____ 1- Hard Anodize Black and Prime as per Dwg 646.3600	Firmed	3/26/18	12 pcs	0 pcs	12 pcs	\$7.43/pcs	\$89.16
5	170466	646.3711	Clip Issue P/O to ATG: _____ Hard Black Anodize and Prime as per Dwg 646.3700 Rev. A	Firmed	3/26/18	21 pcs	0 pcs	21 pcs	\$6.93/pcs	\$145.53
6	170467	646.3712	Clip Issue P/O to ATG: _____ Hard Anodize, Color Black and Prime as Per Dwg 646.3712 Rev. A	Firmed	3/26/18	19 pcs	0 pcs	19 pcs	\$6.93/pcs	\$131.67
7	170468	646.3713	Gusset Issue P/O to ATG: _____ Hard Anodize, Color Black and Prime as per Dwg 646.3700	Firmed	3/26/18	21 pcs	0 pcs	21 pcs	\$16.58/pcs	\$348.18

Plex 3/14/18 10:36 AM dart.lavoie.chanta

PURCHASE ORDER

3/14/2018

				Items									
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price			
8	170469	646.3714	Gusset Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 646.3700 Rev. A	Firmed	3/26/18	21 pcs	0 pcs	21 pcs	\$16.58/pcs	\$348.18			
9	173035	647.2114	Upper U Channel Issue P/O to ATG : _____ 1- Anodize as per MPP-172 sect. 2.1 2- Pretreatment as per MPP-172 sect. 3.3 3-Prime as per MPP-172 sect. 4.3 As Per Dwg 647.2100 Rev. E	Firmed	3/26/18	10 pcs	0 pcs	10 pcs	\$12.08/pcs	\$120.80			
10	172472	647.7820	Cross Bracket Aft Outsource process-Anodize per QSI017 4.1.10.1 Issue P/O TO ATG: _____ Anodize & prime as per Dwg. 647.7800	Firmed	3/26/18	1 pcs	0 pcs	1 pcs	\$12.08/pcs	\$12.08			
11	171212	647.7911	Bracket Issue P/O to ATG: _____ AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.2, PRIME AS PER IAW MIL-PRF-23377 TYPE 1 CLASS N as per Dwg 647.7900 Certification of Conformity is required	Firmed	3/26/18	9 pcs	0 pcs	9 pcs	\$7.73/pcs	\$69.57			
12	171380	RBE350A93-3302-02-1	Handle -Issue P/O to ATG: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3302-02-1 Rev. 11 -Certificate of Conformity is required	Firmed	3/16/18	6 pcs	0 pcs	6 pcs	\$6.08/pcs	\$36.48			
13	170577	RBE350A93-3500-00-1	Body -Issue P/O to ATG: _____ -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant as per Dwg RBE350A93-3500-00-1 Rev. 3A -Certificate of Conformity is required	Firmed	3/16/18	6 pcs	0 pcs	6 pcs	\$5.51/pcs	\$33.06			
14	171139	RBE350A93-3501-20	Extraction Tool, Hydraulic Pump Pulley Bearing -Issue P/O to ATG: _____ -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant As Per Dwg RBE350A93-3501-20 Rev. E -Certificate of Conformity is required	Firmed	3/19/18	20 pcs	0 pcs	20 pcs	\$5.51/pcs	\$110.20			
15	170701	RBT112800-1	Base -Issue P/O to ATG: _____ ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL As per Dwg RBT112800 Rev. 3A -Certificate of Conformity is required	Firmed	3/19/18	6 pcs	0 pcs	6 pcs	\$5.51/pcs	\$33.06			

DAS
11
9-89

Plex 3/14/18 10:36 AM dart.lavoie.chanta



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914804

Date: 22-Mar-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		OUR TRUCK	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
6 ea	Part: D5501-3 Body, Lower Cutter, Short Hard-Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - 2 mils) per drawing. Job: 22631 PO: PO039182 Line: 1 Rev: A7		
① ea	Part: 647.7820 Cross Bracket Aft Outsource process - Anodize per QSI017 4.1.10.1 Job: 22640 PO: PO039182 Line: 10 Rev: A		
21 ea	Part: 646.3711 Clip ANO/PRIME1 Job: 22635 PO: PO039182 Line: 5 Rev: A		
19 ea	Part: 646.3712 Clip Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22636 PO: PO039182 Line: 6 Rev: A		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>22/03/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ Made in Canada.			

